

Date: Wednesday, 03/09/2008 10:29:29 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARSHOE
Job Number	: 41737		
Estimate Number	: 10330		
P.O. Number	:	Part Number	: D2746
This Issue	: 03/09/2008 S.O. No. :	Drawing Number	: D2746 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 35496	Material	:
Written By	:	Due Date	: 30/09/2008 Qty: 12 Um: Each
Checked & Approved By	: <u>JUD 089.03</u>		
Comment	: Est Rev: D 02.10.24 Re-format KJ		
	: Est Rev: E 06-03-21 as Per Rev C JLM		
	: Est Rev: F 06-06-12 Now On Waterjet JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S20GA	1010/1025 SHEET
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Comment: Qty.: 0.4263 sf(s)/Unit Total : 5.1156 sf(s)  
 1010/1025/A21/6aA .040" SHEET  
 (M1010S20GA)  
 Batch: 107906 HB 8-9-15

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D2746  
 Dwg Rev: C  
 Prog Rev: C

HB 8-9-15



2-Deburr if necessary

HB 8-9-15

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 8-9-15

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 08/09/15 (12)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Deburr if necessary.

u/h Done at step 2.2

8/9/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 03/09/2008 10:29:29 AM  
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Drawing Name: WEARSHOE

Job Number: 41737

Part Number: D2746

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on CNC Brake as per Dwg D2746 using Jigs DT8261 and DT8326

2-Form joggle on Punch as per Dwg D2746 using Jig DT8158 Identify as D2746

SB 08/09/16 (12)  
SB 08/09/16 (12)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/09/16 (12)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:30  
320 °F  
8:00

M-1 08/09/19

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-09-19 (12)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST496 P-8/15 (12)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/19

Job Completion



MF 08-09-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

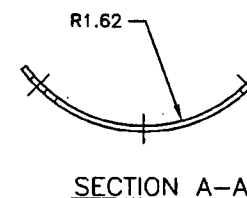
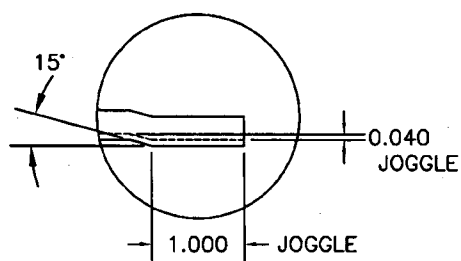
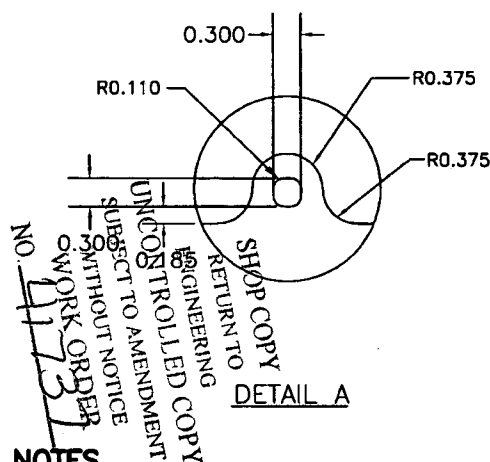
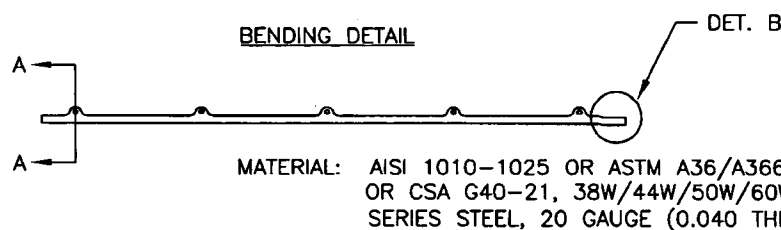
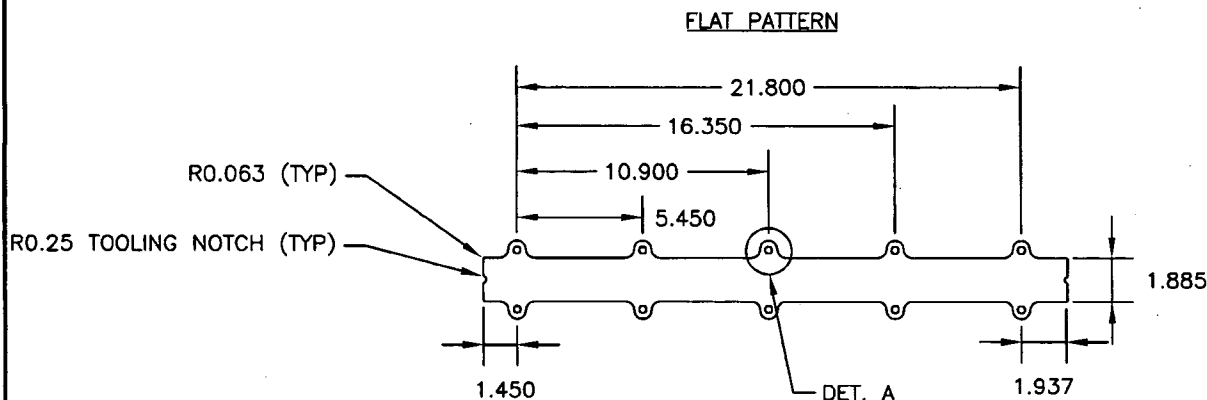
**NOTE:** Date & initial all entries



**DART**

RELEASED  
06-02-07

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	PORT HADLOCK, WA	REV. C
PH1	PH1			
CHECKED	APPROVED	DRAWING NO.		SHEET 1 OF 1
PH1	PH1	D2746		
DATE	TITLE		SCALE	
06.01.12	WEARSHOE		1:8	
A	98.04.16	NEW ISSUE		
B	98.08.18	RE-DESIGN		
C	06.01.12	ENLARGE HOLES TO IMPROVE FIT		



**NOTES**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL, 20 GAUGE (0.040 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) THIS PART CAN BE MADE BY MODIFYING D2656-21